

Work Order ID 62582

Monday, October 04, 2010 1:47:56 PM



Page 1

Item ID: PB67-43001-03

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *10-10-04* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-03	Rev C

Pick kit

10/10/12(13) SP

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001
page 2. ☐ 242 THREADLOCK batch: *11109687*

10.10.19

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/10/19

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PP 63058

10/10/2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62582

Monday, October 04, 2010 1:47:56 PM



Page 2

Item ID: PB67-43001-03

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/20 [Signature]
MF
10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Page 1

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010


Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
C 10.09.24 as per Rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

240-107  SPRING SLOTTED PIN		Purchased	No			100	Each	165.0000	8	8			
---	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--


Location Loc Qty Loc Code

ST400 165
112813 65
115827 100

30345T21  LANYARD		Purchased	No			100	Each	38.0000	1	1			
---	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST401 38
17828 38

30345T24  LANYARDS		Purchased	No			100	Each	46.0000	3	3			
--	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST401 46
111351 2
112853 44

30345T22
LANYARDS

112853

10.10.19 2

(P10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-03 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 4 Date: 10/10/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>62582</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.10.19</u>		QTY (2) 30345 T22 CANARDS USED WITHIN OR QTY (2) 30345 T24 P.C. 30345 T22 + 30345 T24 STORED IN SAME BIN	<u>10.10.19</u>	ACCEPTABLE DEVIATION THIS BIN QTY. STILL FUNCTIONAL.	<u>10.10.19</u> <u>KE</u>	<u>10.10.19</u>	<u>10.10.19</u>	<u>10.10.19</u>

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

3408A98

Purchased

No

100

Each

14.0000

1



10/10/12 SP

DETENT BALL SPRING PLUNG

Location

Loc Qty

Loc Code

ST401

14

111078

4

115703

10

1

AN4-10A

Purchased

No

100

Each

118.0000

2



2
10/10/12 SP

Bolt

Location

Loc Qty

Loc Code

ST356

118

113422

1

114523

77

115835

40

0

AN4-13A

Purchased

No

100

Each

480.0000

1



1
10/10/12 SP

Bolt

Location

Loc Qty

Loc Code

ST358

480

115159

480

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-15A

Purchased

No

100

Each

577.0000

4

4



colulias

Bolt

Location

Loc Qty

Loc Code

ST338

112

ST358

465

107737

12

108868

60

109148

4

111295

52

112905

12

114232

3

114292

32

114615

56

114784

58

115108

76

115371

100

AN5-26A

Purchased

No

100

Each

28.0000

1

1



colulias

Bolt

Location

Loc Qty

Loc Code

ST339

28

112492

28

AN6-11A

Purchased

No

100

Each

84.0000

2

2



colulias

BOLT

Location

Loc Qty

Loc Code

ST342

84

105558

4

111177

30

114437

50

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03


Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010


Start Qty: 1.00

Required Qty: 1.00

AN6-16A	Purchased	No	100	Each	38.0000	2	2	<u>10/10/2010</u>
								
BOLT								


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST342	38	
<u>111636</u>	38	<u>2</u>

AN8-13A	Purchased	No	100	Each	18.0000	2	2	<u>10/10/2010</u>
								
BOLT								


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST345	18	
<u>110915</u>	18	<u>2</u>

BSP43	Purchased	No	100	Each	62.0000	3	3	<u>10/10/2010</u>
								
RIVET								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST284	62	
<u>110704</u>	50	<u>3</u>
<u>111127</u>	12	

CR3213-4-05	Purchased	No	100	Each	140.0000	1	1	<u>10/10/2010</u>
								
cherry rivet								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST312	140	
<u>108473</u>	41	<u>1</u>
<u>108991</u>	99	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3440-1 Manufactured No

100 Each

11.0000

1



10/10/2010

Tube Guide (Supersedes B67-43001-25/-307)

Location

Loc Qty

Loc Code

ST441

11

40047

8

41347

3

D3440-3 Manufactured No

100 Each

3.0000

1



10/10/2010

Clamp (Supersedes B67-43001-309)

Location

Loc Qty

Loc Code

ST441

3

41348

3

D3444-1 Manufactured No

100 Each

7.0000

1



10/10/2010

Velcro Loop Belt

Location

Loc Qty

Loc Code

ST441

7

41457

7

D3447-9 Manufactured No

100 Each

8.0000

2



10/10/2010

Swing Arm

Location

Loc Qty

Loc Code

ST442

8

46263

2

57745

6

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03


Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010


Start Qty: 1.00

Required Qty: 1.00

D3449-1 Manufactured No 100 Each 6.0000 1 1

 Pad


Location Loc Qty Loc Code

FG 6
 62128 6

D3451-043 Manufactured No 100 Each 2.0000 1 1

 Handle and Lock-Down Assembly


Location Loc Qty Loc Code

ST442 2
 52566 2

D3451-045 Manufactured No 100 Each 2.0000 1 1

 Handle and Lock-Down Assembly


Location Loc Qty Loc Code

ST442 2
 52567 2

D3922-1 Manufactured No 16.0000 1 1

 Clip

Location Loc Qty Loc Code

ST096 16
 48459 16

MS17984-C408 Purchased No 13.0000 1 1

 PIN, QUICK RELEASE

Location Loc Qty Loc Code

ST314 13
 111279 3
 112940 10

Monday, October 04, 2010 1:47:55 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS17984-C418

Purchased

No

100

Each

30.0000

3

3



10/10/13 SP

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST314

24

111359

2

112940

2

114523

20

ST463

6

114416

6

2

1

MS21042L4

Purchased

No

100

Each

4,434.000

9

9



10/10/13 SP

Nut

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

9

MS21042L5

Purchased

No

100

Each

899.0000

1

1



10/10/13 SP

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

873

115156

373

115594

500

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L6 Purchased No 100 Each 244.0000 4 4



Nut



10/10/135

Location Loc Qty Loc Code

ST300 244

111578 4

114495 40

115300 200

MS24694-S109 Purchased No 100 Each 50.0000 2 2



Screw, Flat Head



10/10/138

PTO

Location Loc Qty Loc Code

ST303 50

115708 50

MS27039-1-07 Purchased No 100 Each 211.0000 1 1



Screw



10/10/138

Location Loc Qty Loc Code

ST291 211

18106 211

MS27039-1-23 Purchased No 100 Each 28.0000 1 1



SCREW



10/10/138

Location Loc Qty Loc Code

ST292 28

18057 28

W/O: 62582		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.18		MS24694-S101 TOO LONG. PERMANENT CHANGE TO MS24694-S102 <i>open PAR</i>				<i>10.10.18</i> <i>CS1012</i>	

Part No: PB67-43001-03 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03


Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010


Start Qty: 1.00

Required Qty: 1.00

MS51859-6 Purchased No 100 Each 121.0000 8 8

 WASHER 10/10/138


Location Loc Qty Loc Code

ST296 121
 111279 21
 112940 100

MS51859-7 Purchased No 100 Each 25.0000 2 2

 Washer 10/10/138


Location Loc Qty Loc Code

ST296 25
 111193 25

MS51859-8 Purchased No 100 Each 63.0000 8 8

 WASHER 10/10/138

Location Loc Qty Loc Code

ST296 63
 112940 63

NAS1149F0316P Purchased No 100 Each 287.0000 1 1

 WASHER 10/10/138

Location Loc Qty Loc Code

ST275 287
 112940 87
 113237 100
 113644 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

290.0000

16

16



10/10/138

Washer

Location

Loc Qty

Loc Code

ST275

290

112940

92

114405

1

114576

10

114718

8

115698

179

16

NAS1149F0532P

318057 = 2

WASHER

PTC

10.10.19

NAS1149F0632P

Purchased

No

100

Each

481.0000

8

8



10/10/138

WASHER

Location

Loc Qty

Loc Code

ST275

481

18057

481

NAS1149F0832P

Purchased

No

100

Each

275.0000

2

2



10/10/138

WASHER

Location

Loc Qty

Loc Code

ST275

275

18057

275

NAS43DD3-6J

Purchased

No

100

Each

0.0000

1

1



PTO.

Spacer

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

1



10.10.13 362309

Aft Blade Fold Assembly Weldment

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

1



362364 10.10.15

Aft Adjustable Blade Support Assembly

Monday, October 04, 2010 1:47:55 PM

Shop Packet Print

W/O: 62582		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.18		ADD FOLLOWING ITEM: NAS1149 FO 532P, QTY = 2. PERMANENT CHG.	AA	10.10.20		10.10.18 AS1018	10.10.20

Part No: PB67-43001-03 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 7 Date: 10/10/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 62582		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.15		NAS 43003-68 CUT TO LENGTH OF NAS 43003-61: 0.953". QC: NO STOCK FOR -61.	10.10.15	ACCEPTABLE DEVIATION.	10.10.19 H	10.10.19	10.10.15	10.10.19

NOTE: Date & initial all entries

Picklist Print

Page 11

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-135 Manufactured No

100 Each

6.0000

1



Male Eye

10/10/13SL

Location

Loc Qty

Loc Code

ST446

6

45000

6

PB67-43001-137 Manufactured No

100 Each

0.0000

1



Locking Sleeve

PB67-43001-155 Manufactured No

100 Each

16.0000

1



Pin

10/10/13SL

Location

Loc Qty

Loc Code

ST446A

16

43092

16

PB67-43001-17 Manufactured No

100 Each

0.0000

1



Aft Adjustable Blade Support Assembly

PB67-43001-21 Manufactured No

100 Each

0.0000

1



PB67-43001-21

PB67-43001-23 Manufactured No

100 Each

0.0000

1



PB67-43001-23

PB67-43001-261 Manufactured No

100 Each

5.0000

2



Lever Arm

10/10/13SL

Location

Loc Qty

Loc Code

ST432

5

52493

5

2

Monday, October 04, 2010 1:47:55 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-265 Manufactured No
Deltin Bushing

100 Each 20.0000



5 5
10/10/138

Location	Loc Qty	Loc Code
ST439	20	
40056	15	
52494	5	

PB67-43001-299 Manufactured No
Bushing

100 Each 20.0000



2 2
10/10/138

Location	Loc Qty	Loc Code
ST439A	20	
44969	20	

PB67-43001-305 Manufactured No
Bearing

100 Each 3.0000



1 1
10/10/138

Location	Loc Qty	Loc Code
ST439A	3	
47044	3	

PB67-43001-37 Manufactured No
Tube Arm Assembly

100 Each 1.0000



1 1
10.10.15

Location	Loc Qty	Loc Code
ST446	1	
53250	1	

PB67-43001-57 Manufactured No
Stabilizer Arm

100 Each 0.0000



1 1
B62129 10/10/138

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

Monday, October 04, 2010 1:47:55 PM

Work Order ID: 62582



Parent Item: PB67-43001-03



Parent Item Name: Aft Blade Fold Assembly

Start Date: 10/5/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-59 Manufactured No

100

Each

1.0000

1

1



10/10/13

PB67-43001-59

Location

Loc Qty

Loc Code

ST437A

1

53308

1

PB67-43001-63 Manufactured No

100

Each

2.0000

1

1



10/10/13

Handle Assembly

Location

Loc Qty

Loc Code

ST444

2

53243

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

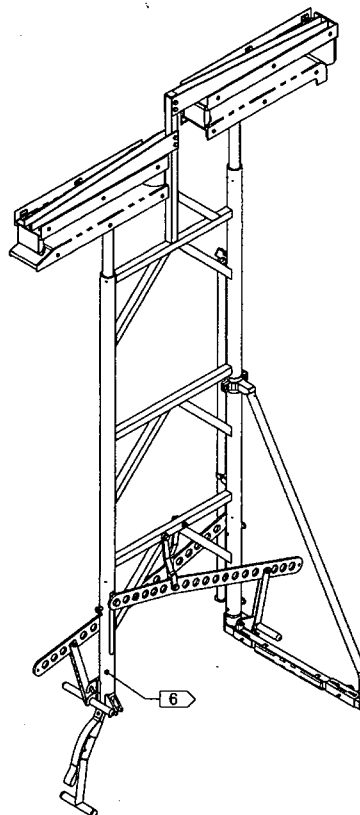
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELTRIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
29	2	AN4-10A	BOLT
30	1	AN4-13A	BOLT
31	4	AN4-15A	BOLT
32	1	AN5-26A	BOLT
33	2	AN6-11A	BOLT
34	2	AN6-16A	BOLT
35	2	AN8-13A	BOLT
36	3	BSP43	RIVET
37	1	CR3213-4-05	RIVET
38	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
39	1	MS17984-C408	QUICK RELEASE PIN
40	3	MS17984-C418	QUICK RELEASE PIN
41	9	MS21042L4	NUT
42	1	MS21042L5	NUT
43	4	MS21042L6	NUT
44	2	MS24694-S109,	SCREW
45	1	MS27039-1-07	SCREW
46	1	MS27039-1-23	SCREW
47	8	MS51859-6	NYLON WASHER
48	2	MS51859-7	NYLON WASHER
49	8	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0316P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER



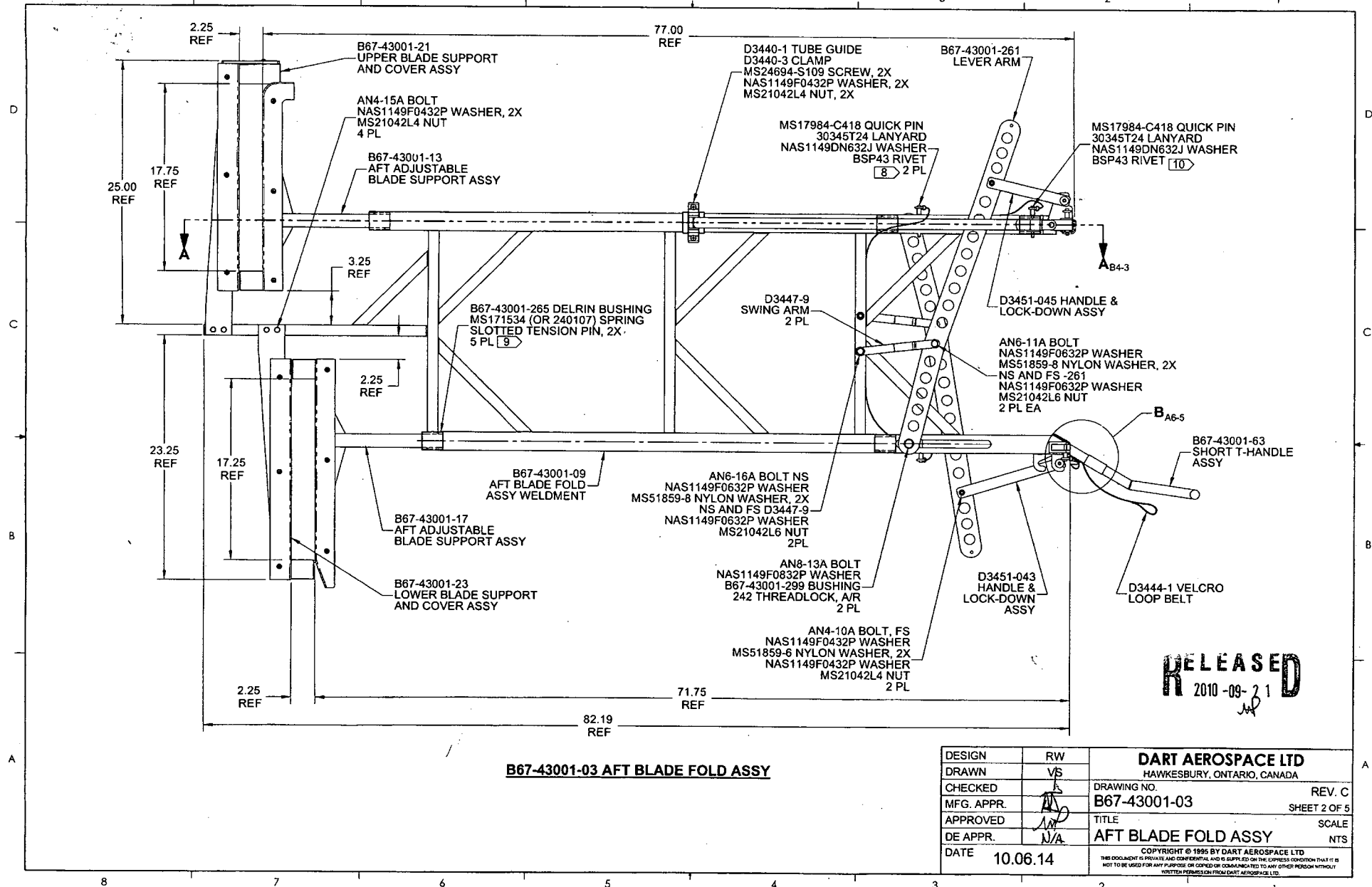
B67-43001-03 AFT BLADE FOLD ASSY

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
 - 7) WEIGHT: 50.57 lbs
 - 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
 - 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 10 PL (2 PL PER BUSHING)
 - 10) DRILL $\phi 0.250$ DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
 - 12) DRILL A $\phi 0.128$ DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
 - 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A $\phi 0.128$ DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
 - 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

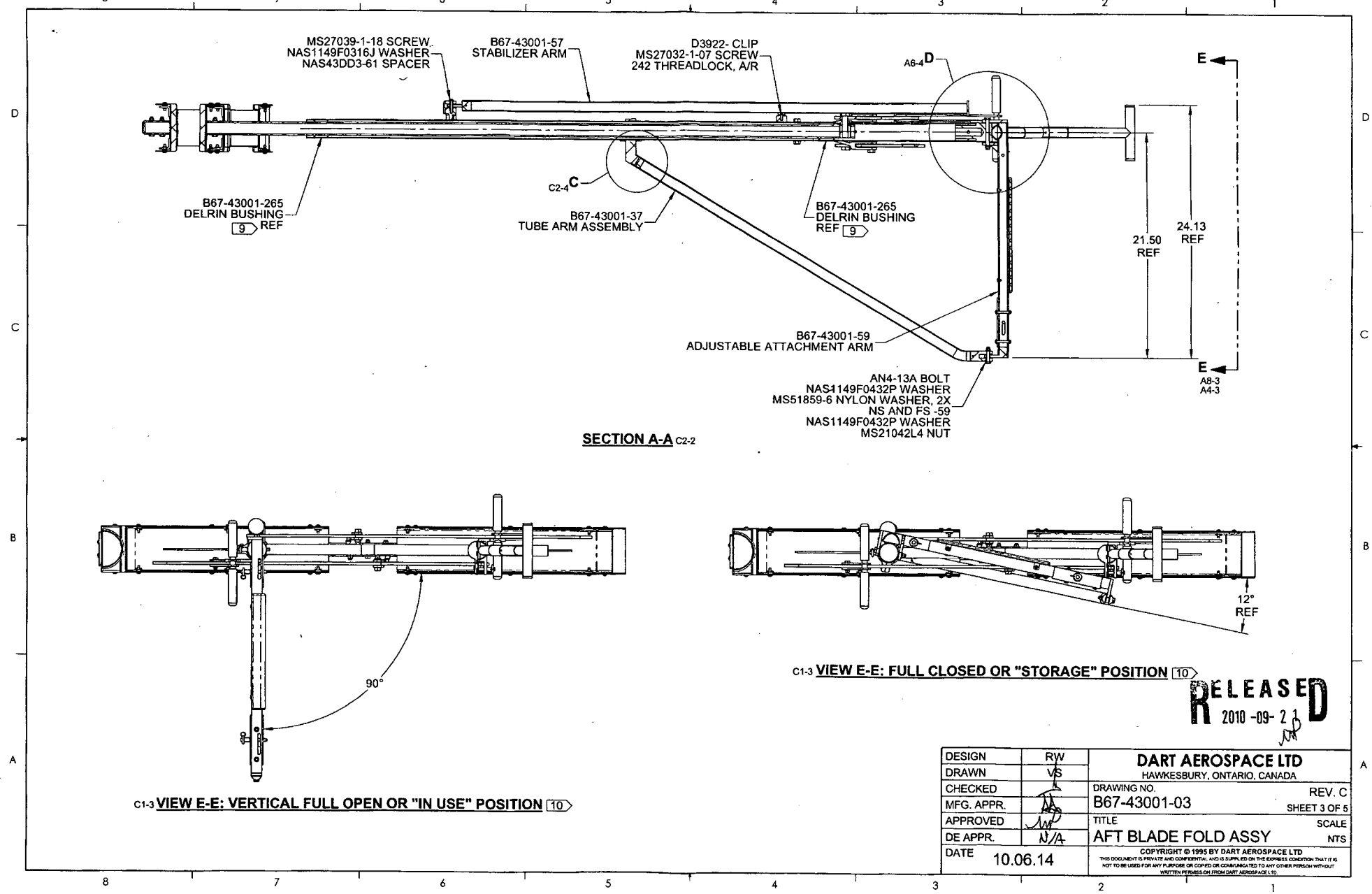
RELEASED
2010-09-21
JMP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011	VS	10.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	WA	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#62582






62580

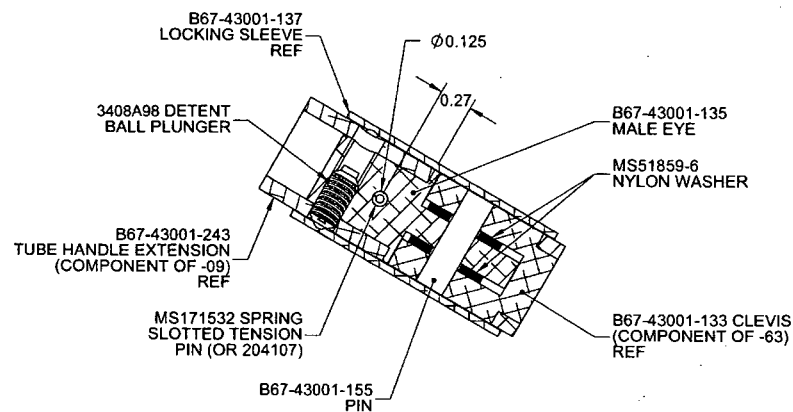


RELEASED
2010-09-23

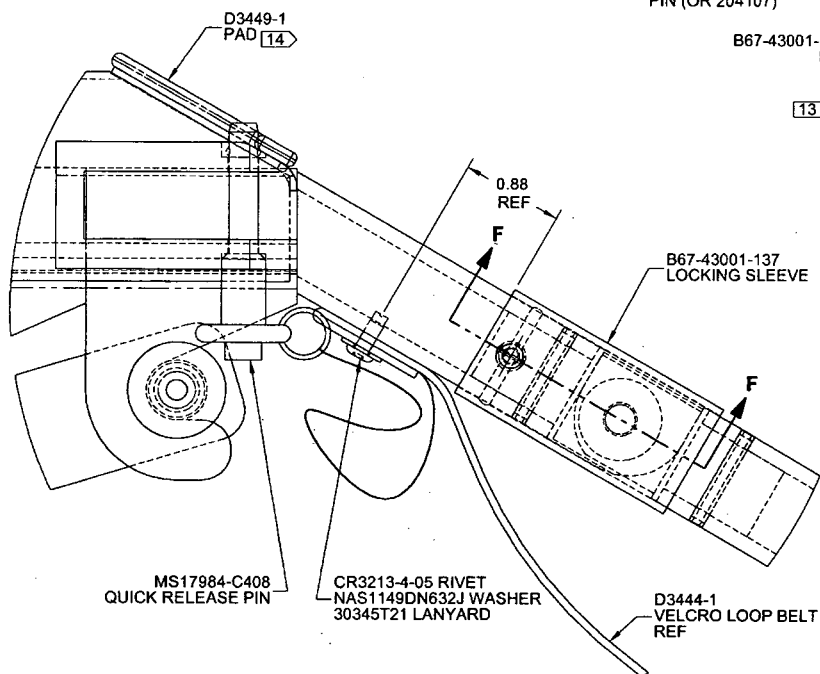
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 0
MFG. APPR.		B67-43001-03	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO YOU EXPRESSLY CONDITIONAL THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

#62580



13 SECTION F-F B4-5



13 DETAIL B C2-2
SCALE 10X

RELEASED
2010-09-21

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.	h	B67-43001-03	SHEET 5 OF 5
APPROVED	h	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	